

Work Order ID 105746

105746

Page 1

August-16-13 11:39:10 AM

Item ID: D3186-2M Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: SPACEPOD DOOR RH
Start Date: 8/16/13 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/13/13 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MLS Date: 13-08-16 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3186	Rev E
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100		0.00
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1000

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 20980
Description: D3186-2MDoor

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

0.00

110

1100

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

0.00

0.00

? 11B-8-1613/12/13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 105746

August-16-13 11:39:10 AM

105746

Page 2

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: SPACEPOD DOOR RH
Start Date: 8/16/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/13/13 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				①	②	13-01-03	
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: _____	0.00				①	②	13-01-03	
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13-01-03

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
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		<input type="checkbox"/> Other

Picklist Print

Page 1

August-16-13 11:39:14 AM

Work Order ID: 105746

105746

Parent Item: D3186-2M

D3186-2M

Parent Item Name: SPACEPOD DOOR RH

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P		Purchased	No			110	Each	1.0000	1	1			

D3186-2P

Spacepod Door

**

105746 *P 13/14/13*

Location

Loc Qty

Loc Code

CA

1

95612

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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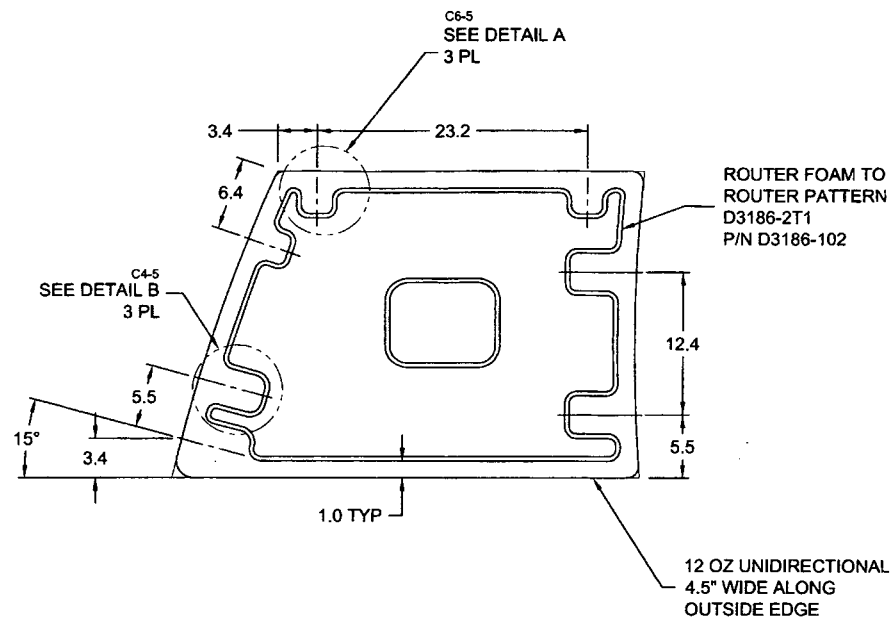
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		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
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		<input type="checkbox"/> Other

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



105746 MJS
 13-08-16

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2009-09-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	50126
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
17-12-2013	11-09-2013	23834	Chantal Lavoie	20980	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		MP MONTAMBEAULT ext 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0060	Line 4 N° D3186-2M Spacepod Door RH U of M: Chaque Dwg. D3186 Rév.: E B105747 - 46 - Serial # Lot # 56879 56879	
1	0	1	DKC134-0071	Line 7 N° D3188-2M, Spacepod Body RH U of M: Chaque Dwg. D3188 Rév.: F Serial # Lot # 56881 56881	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2013-10-29 14:06:23
Utilisateur: Mario Chantal

Feuille de Procédé

4 / 29

Client : DART US DART AEROSPACE
Numéro Job : 56879
Numéro : 3769
Numéro B.A. :
Cette fois : 2013-10-29 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 55560Nom Dessin : SPACEPOD DOOR RH
Numéro Article : DKC134-0060
Numéro Dessin : -
Projet Numéro : DK-362
Révision dessin :
Matériel : 7781 & 411-350
Date Dûe : 2013-11-05 Qté: 1 Ud UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de dessin: D3186-2M rev. E

E.O.: N/A

Feuille de Procédé Rév.: 03 AMB0349 remplacé par
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:

# Séq.: Machine ou Description :
1.0 AAC1616 N° 83634, Frekote Loctite WoloComment Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo N° de Lot: 1-42289-1

2.0 PRÉPARATION Préparation du moule



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: 27/11/13 Sceau: 4460 R.L.

3.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

4.0 AAC1887 Wrighton 5200 Bleu P3

Comment Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrighton 5200 Bleu P3 # de Lot: N/A

5.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 56879

Numéro DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 4.50 VERGE(s)/Unit Total: 4.50 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-43410-1

8.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 2.2500 ROULEAU(s)/Unit Total: 2.2500 ROULEAU(s)

9.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 1.00 VERGE(s)/Unit Total: 1.00 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

10.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 27-11-13 Sceau: 11460 RL

11.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0080 GALLON(s)/Unit Total: 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

12.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.500 LITRE(s)/Unit Total: 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-43187-1

13.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 27/11/13 Sceau: 4460 R.L.



Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

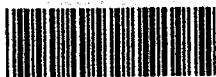
Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 56879

Numéro DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date:

27/11/13

Sceau:

4460 R.L.



15.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing:

11:15

Heure Fin Curing:

8:00

Date:

27/11/13

Sceau:

4460 R.L.



16.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-43187-1

18.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date:

27/11/13

Sceau:

4460 R.L.

19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2)

N° de Job:

57713

Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 56879

Numéro DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

20.0

AAC1611

Polybond B46F

Comment Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)

Polybond B46F

N° de Lot:

1-40397-1

21.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date:

28/11/13

Sceau:

4460 R.L. 4499 D.B.



22.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing:

12:35

Heure Fin Curing:

1:48

Date:

28/11/13

sceau:

4460 R.L. 4499 D.B.



23.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27821-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-43767-1

Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 56879

Numéro DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

25.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 29/11/13 Sceau:



26.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 13 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 29/11/13 Sceau:



27.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 12:15

Heure Fin Curing: 8:00

Date: 29/11/13 Sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 02-12-13 Sceau:



Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 56879Nom Dessin: SPACEPOD DOOR RH
Numéro DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description:

29.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 02-12-13 Sceau:



30.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-43178-2

31.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

32.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 3/12/13 Sceau:



de fiche de mélange: 6517

33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler N° de Lot: 1-43091-1

34.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 04-12-13 sceau: 4499 D.B.

35.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-43178-2

Date: Mardi, 2013-10-29 14:06:23

Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 56879

Nom Dessin: SPACEPOD DOOR RH
Numéro: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

36.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0300 UNITE(s)/Unit Total: 0.0300 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

37.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 5/12/13 Sceau:  # de Fiche de mélange: 6521

38.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 6 Dec 13 Sceau: 

39.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: DEC 09 2013 Sceau: 